

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011765**Date Inspected:** 29-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR

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|------------------------------------|----------------------------------|-----------|------------|----------------------------------|--------------------|-----------|------------|
| CWI Name: | M. Gregson, J. Salazar, G. Mundt | | | CWI Present: | Yes | No | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | | | Component: | Hinge K Pipe Beams | | |

Summary of Items Observed:

The Quality Assurance Inspector Sean Vance arrived on site at Oregon Iron Works, Inc (OIW) in Clackamas, OR, to randomly observe the in process welding of the Hinge K Pipe Beam assemblies. The QA Inspector arrived on site to randomly observe the OIW Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

Hinge-K Pipe Beam Assembly 102A-3**a111-3 Forging to a110-3 Base Plate**

The QA Inspector noted that the excavations were previously completed on the Critical Weld Repairs (CWR's) #2244-015, 016, 017, 018, 019, 020 and 021. The QA Inspector noted that 100% visual/magnetic particle testing had been previously performed, by OIW QC Inspector Jose Salazar, on the completed excavations. The QA Inspector noted that QC Inspector had performed the visual testing per AWS D1.5 and the magnetic particle testing per the OIW procedure QC-113, Rev. #3. The QA Inspector noted that no rejectable indications were found by QC Inspector Salazar and that OIW has received State approval to start the flux core arc welding (FCAW) on the repairs. The QA Inspector noted that QC Inspector Jose Salazar had previously measured the excavations and recorded the measurements as follows: CWR #2244-015, approximately 35mm L x 25mm W x 25mm D, CWR #2244-016, approximately 35mm L x 10mm W x 6mm D, CWR #2244-017, approximately 50mm L x 18mm W x 5.5mm D, CWR #2244-018, approximately 55mm L x 20mm W x 8mm D, CWR #2244-019, approximately 18mm L x 10mm W x 5.5mm D, CWR #2244-020, approximately 20mm L x 30mm W x 6mm D and CWR #2244-021, approximately 50mm L x 12mm W x 5.5mm D. The QA Inspector verified the above measurements and performed 100% visual/magnetic particle testing on the excavations. The QA Inspector found no rejectable indications and completed the applicable Magnetic Testing report (TL 6028), on this date. See attached pictures

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below.

Hinge-K Pipe Beam Assembly 102A-2

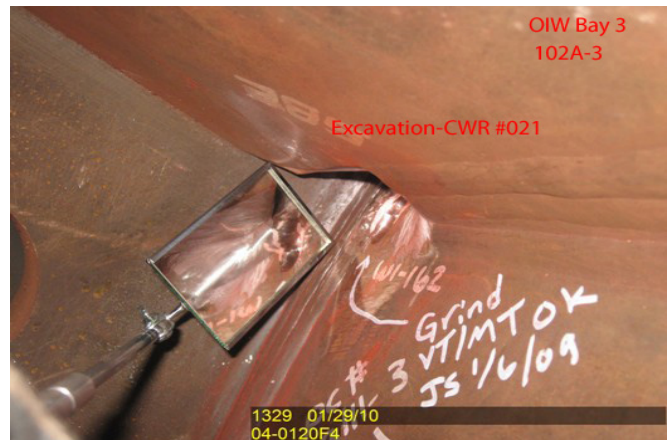
a111-2 Forging to a110-2 Base Plate

The QA Inspector noted that OIW is continuing to perform the machining on the completed HPS 485W stiffeners. See attached picture below.

Material, Equipment, and Labor Tracking (MELT)

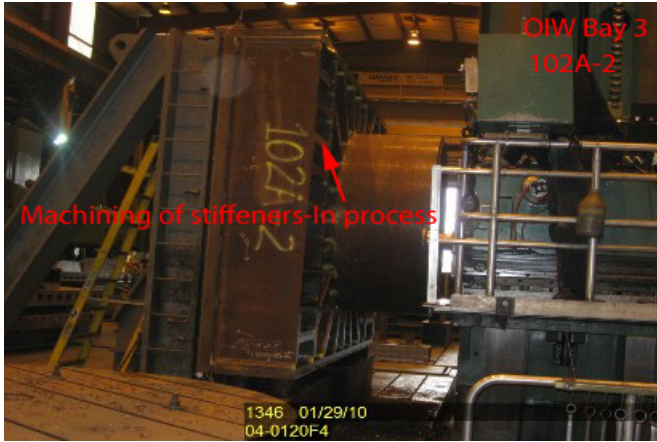
QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project.

The QA Inspector observed at Oregon Iron Works: 2 OIW production personnel and 2 QC Inspectors.



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Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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| Inspected By: | Vance,Sean | Quality Assurance Inspector |
| Reviewed By: | Adame,Joe | QA Reviewer |
